

Date: Monday, 02/03/2009 11:24:08 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CONSOLE
 Job Number : 46179
 Estimate Number : 10910
 P.O. Number :
 This Issue : 02/03/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL /MED FAB
 Previous Run : 44254
 Part Number : D33631
 Drawing Number : D3363 REV C
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 30/03/2009 Qty: 4 Um: Each

Written By :
 Checked & Approved By : JLD 09.03.02
 Comment : Est: B 05.09.09 Remove c'sink rivet holes and add welding stepK
 J/JLM
 Est: C 06.11.15 waterjet EC
 Est Rev:D 08-07-14 add comment in QC5 inspection DD verified
 by:ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S063 6061-T6 .063 Sheet



Comment: Qty.: 2.4150 sf(s)/Unit Total : 9.6600 sf(s)

6061-T6 .063 thick aluminum Sheet

Batch: 110551

B 9-4-4

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3363 ***CUT AT 45 DEG GRAIN DIRECTION*****

Dwg Rev: C

Prog Rev: C

B 9-4-4

(4)

2-Deburr if necessary

B 9-4-4

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B 9-4-4

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 09/04/06 48

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:24:08 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE

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Part Number: D33631

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D3363

SB 09/05/07

(4)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/07 (x4)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld using DT8790 as per Dwg D3363 and QSI 004

PS 09-05-12

4

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BE 09-05-12

(4)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1- inspect part with DT8790 jig

S 09/05/12 (x4)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

cmd/BK

09/05/13

(4)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-13

(x4)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CA

SB 09/05/14

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:24:09 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE

Job Number: 46179

Part Number: D33631

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/14 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 4629
Description: Console		Part Number: D3363-1
Inspection Dwg: D3363	Rev: C	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.099	X			
Ø0.128	+0.005/-0.001	.130	X			
Ø0.469	+0.006/-0.001	.471	X			
14.41	+/-0.030	14.41	X			
14.097	+/-0.010	14.97	X			
12.409	+/-0.010	12.409	X			
11.354	+/-0.010	11.355	✓			
10.706	+/-0.010	10.706	✓			
10.081	+/-0.010	10.084	✓			
4.331	+/-0.010	4.334	✓			
3.706	+/-0.010	3.709	✓			
3.058	+/-0.010	3.060	X			
2.004	+/-0.010	2.006	X			
2.366	+/-0.010	2.368	X			
3.100	+/-0.010	3.106	X			
5.040	+/-0.010	5.042	X			
5.415	+/-0.010	5.417	X			
2.25	+/-0.030	2.25	X			
19.965	+/-0.010	19.965	X			
20.366	+/-0.010	20.366	X			
21.318	+/-0.010	21.318	X			
22.90	+/-0.030	22.90	X			
0.315	+/-0.010	.320	✓			
3.706	+/-0.010	3.703	X			
4.025	+/-0.010	4.029	X			
7.206	+/-0.010	7.206	X			
1.75	+/-0.030	1.75	X			
10.387	+/-0.010	10.386	X			
19.590	+/-0.010	19.590	X			

DART AEROSPACE LTD		Work Order:	46179
Description: Console		Part Number:	D3363-1
Inspection Dwg: D3363 Rev: C		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.990	+/-0.010	18.990	✓			
1.80	+/-0.030	1.800	✓			
6.390	+/-0.010	6.394	✗			
5.790	+/-0.010	5.794	✓			
4.475	+/-0.010	4.476	✓			
4.100	+/-0.010	4.100	✗			
2.725	+/-0.010	2.724	✗			
2.00	+/-0.030	1.999	✓			
6.363	+/-0.010	6.363	✗			
10.737	+/-0.010	10.739	✓			
11.206	+/-0.010	11.210	✓			
3.206	+/-0.010	3.208	✗			
3.675	+/-0.010	3.676	✓			

Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	9-4-4	Date:	09/06/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	DA

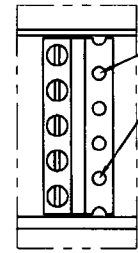
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B11	CH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 3
11	11	D3363	
DATE	TITLE	SCALE	
07.01.26	CONSOLE ASSEMBLY	1:5	
A	04.11.29	NEW ISSUE	
B	05.03.28	INCREASE WIDTH BY 0.125	
C	07.01.26	T'DRILL DZUS RAIL, WIDEN BASE CUTOUT	

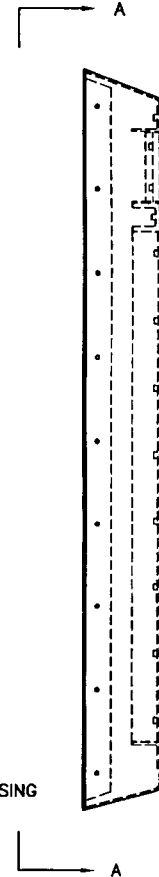
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07.06.04

TRANSFER DRILL #30 FROM D3362-1 DZUS RAIL THROUGH D3363-1 CONSOLE (TYP 4 PLACES) C'SINK (#0.225 X 100") FROM TOP SIDE OF CONSOLE



DETAIL C (SCALE 1:2)



INSTALL D3361-1 & D3362-1 USING MS20426AD4-6 RIVETS (TYP 9 PLACES)

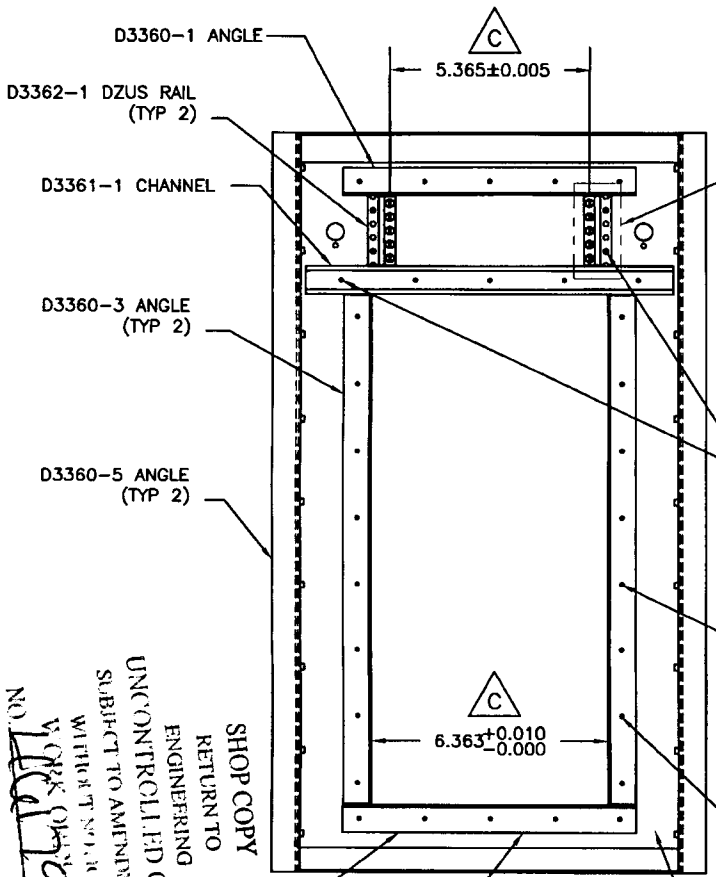
TRANSFER DRILL #30 FROM MATING PARTS THROUGH #40 HOLES IN D3363-1 CONSOLE (TYP 49 PLACES) C'SINK (#0.225 X 100") FROM CONSOLE TOP SIDE

INSTALL D3360-1/-3/-5 ANGLES USING MS20426AD4-5 RIVETS (TYP 44 PLACES)

D3363-1 CONSOLE

PARTS LIST FOR D3363-041 CONSOLE ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
X	D3363-041	CONSOLE ASSEMBLY
2	D3360-1	ANGLE
2	D3360-3	ANGLE
2	D3360-5	ANGLE
1	D3361-1	CHANNEL
2	D3362-1	RAIL
1	D3363-1	CONSOLE
44	MS20426AD4-5	RIVET
9	MS20426AD4-6	RIVET



ALIGN EDGES OF ANGLES W/CUTOUT

VIEW A-A FROM UNDER CONSOLE ASSEMBLY

D3363-041 CONSOLE ASSEMBLY

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH DART P/N D3363-041 AND B/N BXXXXX USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

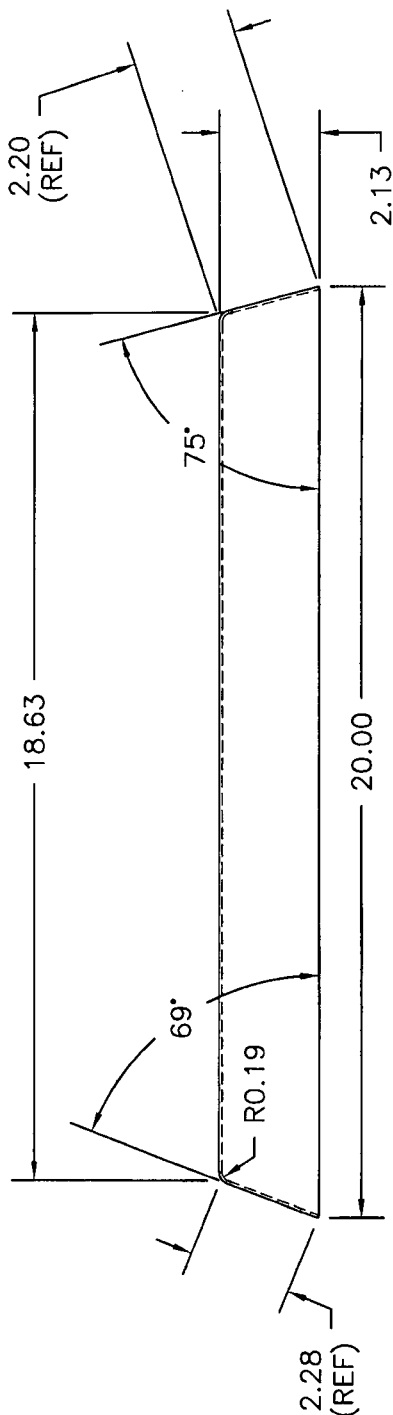
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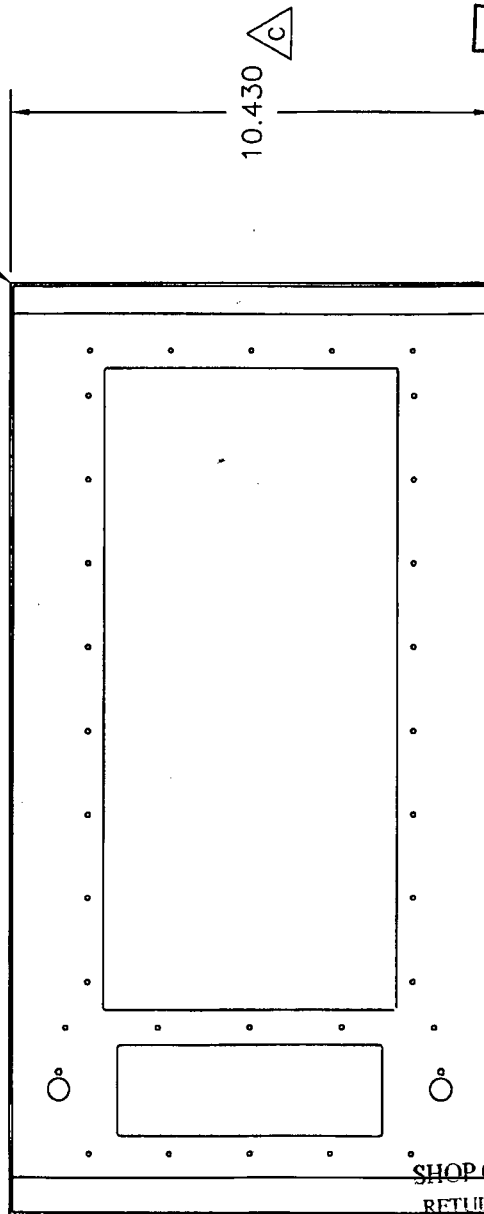
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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26	TITLE CONSOLE ASSEMBLY		SCALE 1:4



GRIND OUTSIDE
WELD FLUSH
(TYP 4 PLACES)



RELEASED

07.06.04 *PH*

D3363-1 BEND DETAIL

(MAKE FROM D3363-1F FLAT PATTERN)

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D3363-1 CONSOLE

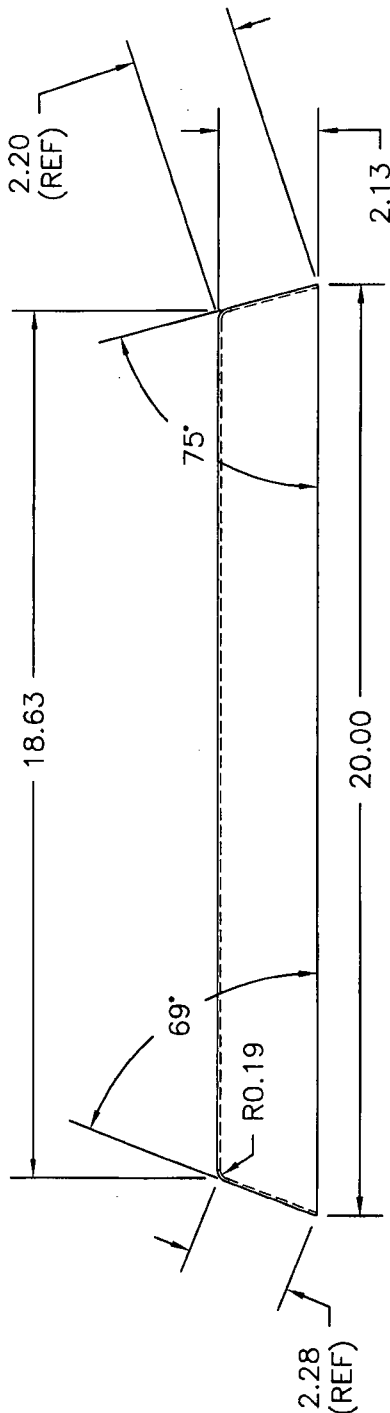
- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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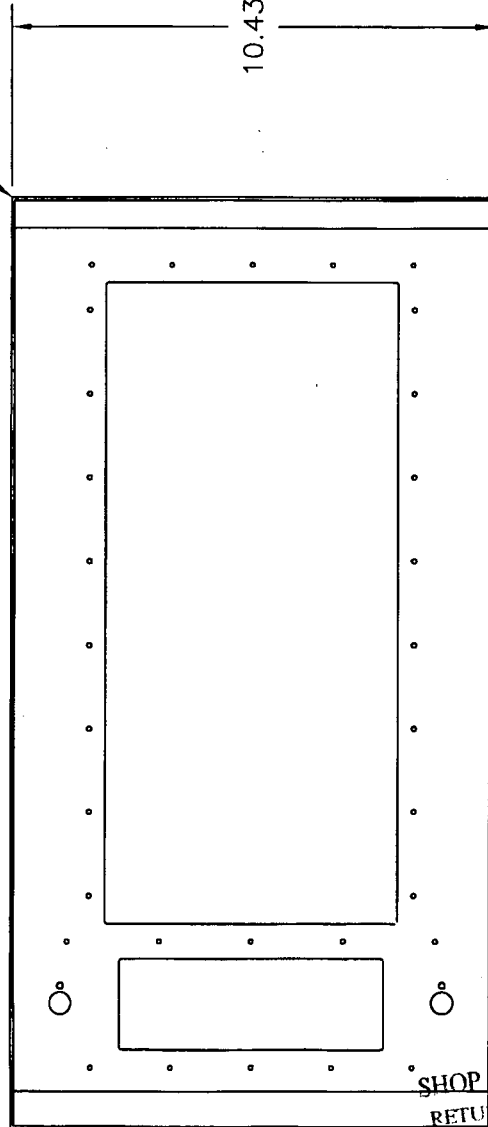
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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26	TITLE CONSOLE ASSEMBLY		SCALE 1:4



GRIND OUTSIDE
WELD FLUSH
(TYP 4 PLACES)



10.430



RELEASED

07.06.04 *PH*

D3363-1 BEND DETAIL
(MAKE FROM D3363-1F FLAT PATTERN)

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W. J. G. C. R.
NO. 460179

D3363-1 CONSOLE

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

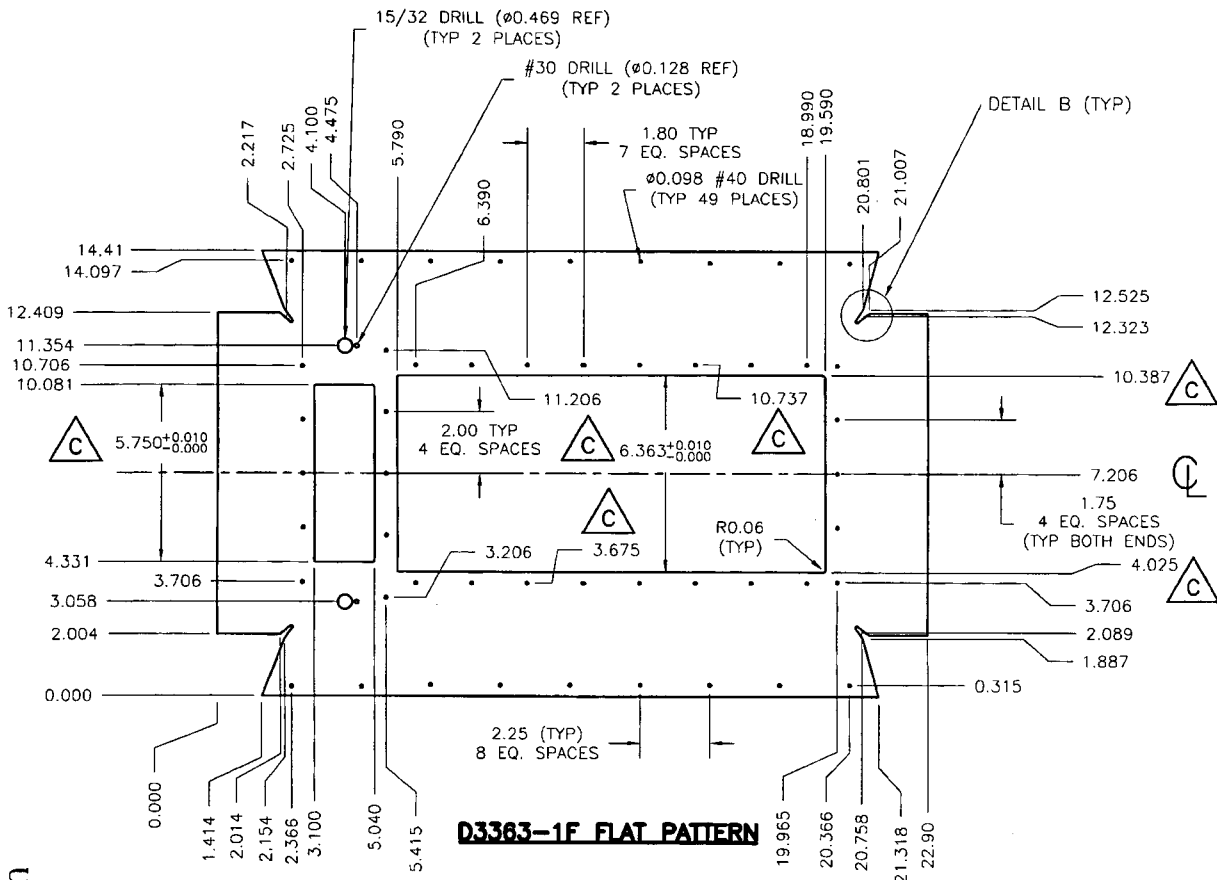
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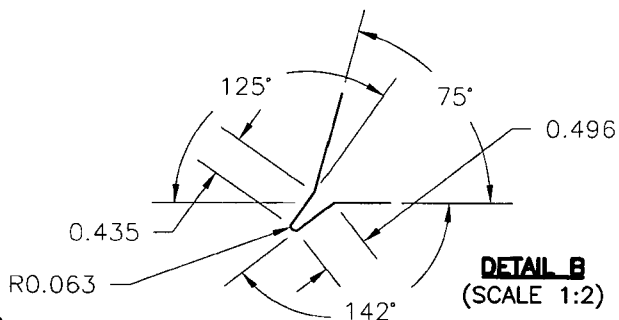
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DATE 07.01.26	DRAWING NO. D3363	SHEET 3 OF 3	
	TITLE CONSOLE ASSEMBLY	SCALE 1:6	

RELEASED
07.06.04



D3363-1F FLAT PATTERN



D3363-1F CONSOLE (FLAT PATTERN)

- 1) MATERIAL: 6061-T6/T651 ALUMINUM 0.063 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE

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